

If any additional fees are due those fees should be charged to Deposit Account No. 50-0581.

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- [0099] ~~figure 52a~~ Figure 52 depicts separated foam of step 2.
- [00100] Figure ~~52b~~ 52a depicts aligned foam of step 3.
- [00110] Figure ~~60e~~ 60 depicts front view of foam construction.
- [00561] The second example is as follows. A bun (such as 30" high, 80" long, 60" wide) of high resiliency polyether-based polyurethane flexible foam is purchased from a foam manufacturer, with an ILD of 50 and a density of 2.8 pounds per cubic foot (considered very durable). Figure 51 shows a example cutting pattern 5101. Each dashed line shows a cut all the way through the width (into the paper). These cuts are made by a CNC reciprocal saw such as is made by Baumer USA and is well known in the art. This is a simpler pattern, and quicker to cut, than the illustration of the previous example. As a further contrast to the previous example, this bun is cut from only one direction rather than turned 90 degrees and cut a second time. When the bun is disassembled as shown in Figure 52 and 52a, very little is discarded. The resulting foam pieces 5201 5212 are bonded together as shown in Figures 52 and 53 with rails 5201 and 5202 being bonded with any of several common foam adhesives to result in the mattress core of the previous example. A cover is then applied. The mattress core has one-piece foam skins which are integral with and which support the foam free-standing rectangular rail within the core. These are the type of rails described above as effectively having one degree of freedom. While this may reduce the overall effectiveness of the cushion compared to buckling members with multiple degrees of freedom, it is still effective and results in a less expensive mattress to produce because cutting time is reduced and waste is minimized.